



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

C3

Job Sheet 175261



503440

Part No: C3

Job Qty: 1 ea

Part Name: C-Series Remote Hook 3,000 lbs Lift Capacity



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/2/18

Job Tracking No:

Due Date: 5/11/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG C3 Rev 2 IPP Rev A 18.03.29 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		5/10/18	0.00	0.00	Start Up Small Fab-4		18-05-25 CB
100	Small Fab	1 pcs		5/11/18	0.00	1.00	Small Fab-3		AP 18-06-11
110	QC	1 pcs		5/11/18	0.00	0.00	QC5		JUN 1 1 2018
120	DC	1 pcs		5/11/18	0.00	0.00	DC		JUN 1 1 2018
130	Packaging	1 pcs		5/11/18	0.00	0.00	Packaging3-2		JUN 1 1 2018
140	QC21-SA	1 Ea		5/11/18	0.00	0.00	QC21		JUN 1 1 2018

Part Op 100 - 1- PICK C3-2-1 AND LASER ENGRAVE AS PER DWG . SEE NOTE 3 AND 4 ON SHEET 3. 2- ASSEMBLE AS
Descriptions: PER DWG

120 - - Photocopy blue file OM & OOPM-C3 Rev 4

130 - Identify and Stock

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/4	Set Screw 943550350	2 Ea (2 ea)	90-Start up Operation	5049572 5058750
188-FSCS-832-5/8	Clock Spring Cover Screw	4 Ea (4 ea)	90-Start up Operation	5058763
2595K22	Heat Shrink Tube	1 Ea (1 ea)	100-Small Fab	5058851
32446	Crimp Terminal	2 Ea (2 ea)	100-Small Fab	5047675
8183K6	Wire Guide/Grip	1 (1 ea)	100-Small Fab	505875450 66770
AN4-16A	Bolt	3 Ea (3 ea)	100-Small Fab	5057519 50 68654
AN4-17A	Bolt	1 Ea (1 ea)	100-Small Fab	502772450 70163
AN6-15A	Bolt	1 Ea (1 ea)	100-Small Fab	5049842
AN960-10	Washer NAS1149F0363P	1 Ea (1 ea)	100-Small Fab	5049842
AN960-10L	Washer, #10 NAS1149F0332P	2 Ea (2 ea)	100-Small Fab	5057525 50 22654
AN960-416	Flat Washer Dia 1/4" NAS1149F0463P	8 Ea (8 ea)	100-Small Fab	5057525 50 58383
AN960-616L	5/8" OD, THIN FLAT WASHER NAS1149F060P	2 Ea (2 ea)	100-Small Fab	5056461
C2-1-1P	Manual Release Knob	1 Ea (1 ea)	100-Small Fab	5048297-1
C2-10-1P	Lock Spring Pin	1 (1 ea)	100-Small Fab	5029232
C2-11-2P	Locating Pin	2 (2 ea)	100-Small Fab	5029231
C2-3-1P	Bearing DU	2 (2 ea)	100-Small Fab	5029438
C2-3-10	Latch Shaft	1 Ea (1 ea)	100-Small Fab	5029243
C2-3-11P	Actuator	1 pcs (1 ea)	100-Small Fab	5046764
C2-3-2P	Latch Roller Pin	1 (1 ea)	100-Small Fab	5029245
C2-3-2-1	Roller Pin Retaining Ring	2 Ea (2 ea)	100-Small Fab	5029246
C2-3-3	Latch Roller	1 (1 ea)	100-Small Fab	5056845
C2-3-3-1P	Latch Roller DU Bearing	1 Ea (1 ea)	100-Small Fab	5068693

used C2-EP 5029261

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																											
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Dart Aerospace Ltd. 1270 Aberdeen Street Newkensbury, ON K6A 1K7 CANADA TEL.: 1 513 632-5200 Email: sales@dartero.com www.dartaerospace.com Container No: S074639 Part: C3 Job No: 175261 Serial No/Batch: S074639 Revision: 2 Inspector: Date: 05/25/18			Completed By																																																										
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OTHER : _____																																																													

C2-3-5 P	Spacer, Teflon	2 Ea (2 ea)	100-Small Fab	5029249
C2-3-6 P	Latch	1 Ea (1 ea)	100-Small Fab	5029250
C2-3-8	Actuator Bushing	2 Ea (2 ea)	100-Small Fab	5046985
C2-5-1 P	Actuator Stop	1 (1 ea)	100-Small Fab	5029254
C3-10-2 P	Lock Spring	1 Ea (1 ea)	100-Small Fab	5029262
C3-11-1 P	Side Plate - Solenoid C3-Hook	1 Ea (1 ea)	100-Small Fab	5029263
C3-12-1	Lock Bushing	2 Ea (2 ea)	100-Small Fab	5035073
C3-12-2 P	Lock Shaft - C3 Hook	1 Ea (1 ea)	100-Small Fab	5075009
C3-12-3 P	Lock - C3 Hook	1 (1 ea)	100-Small Fab	5029265
C3-12-4 P	Lock Roller	1 Ea (1 ea)	100-Small Fab	5029266
C3-12-5 P	Lock Roller Pin	1 Ea (1 ea)	100-Small Fab	5029267
C3-12-6 P	Lock Roller Pin Circlip	2 (2 ea)	100-Small Fab	5029268
C3-13-1 P	Keeper Bushing	2 (2 ea)	100-Small Fab	5029269
C3-13-4 P	KEEPER	1 (1 ea)	100-Small Fab	5029270
C3-13-5 P	Spring, Keeper	1 (1 ea)	100-Small Fab	5029271
C3-2-1 P	Side Plate C-3 Hook	1 Ea (1 ea)	100-Small Fab	5029273
C3-3-4 P	Link Pin	2 Ea (2 ea)	100-Small Fab	5029277
C3-3-4-1	Ring, Retaining	4 pcs (4 ea)	100-Small Fab	5029278
C3-3-7	Link	1 Ea (1 ea)	100-Small Fab	5032318
C3-3-9 P	Actuator Spring	1 (1 ea)	100-Small Fab	5048396
C3-4-1 P	Load Beam Bushing	2 Ea (2 ea)	100-Small Fab	5029280
C3-4-4A P	C3 Load Beam Assy	1 Ea (1 ea)	100-Small Fab	5029281
C3-7-1	Load Beam Bumper	1 Ea (1 ea)	100-Small Fab	5029282
C3-7-2	Lock Bumper	2 Ea (2 ea)	100-Small Fab	5062797
C3-8-2 P	Solenoid	1 (1 ea)	100-Small Fab	5067293
C3-8-4 P	Solenoid Cover Gasket	1 (1 ea)	100-Small Fab	5029285
C3-8-5 P	Solenoid Cover	1 (1 ea)	100-Small Fab	5029287
C3-9-1 P	Clock Spring Cover - C3 Hook	1 (1 ea)	100-Small Fab	5029288
C3-9-2 P	Spring, Clock	1 (1 ea)	100-Small Fab	5029289
EL-PLUG-M	3-Prong Male Spade Plug	1 Ea (1 ea)	100-Small Fab	5029290
M27500-16TG2T14	Wire - 16-Gauge - Shielded	1 (1 ea)	100-Small Fab	5054451
MS21044N4	Nut, Self-Locking	4 Ea (4 ea)	100-Small Fab	50
MS21083-N3	Nut	2 Ea (2 ea)	100-Small Fab	5058122
MS21083N6	Nut	1 Ea (1 ea)	100-Small Fab	5036469
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-Small Fab	5036359
MS35266-63	Solenoid Cover Screw	1 Ea (1 ea)	100-Small Fab	5038767
				5038767

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/4	2	10	0
	188-FSCS-832-5/8	4	84	0
100-Small Fab	2595K22	1	8	0
	32446	2	234	0
	8183K6	1	0	0
	AN4-16A	3	129	0
	AN4-17A	1	272	0
	AN6-15A	1	12	0
	AN960-10	1	3,363	0
	AN960-10L	2	0	0
	AN960-416	8	0	0
	AN960-616L	2	0	0
	C2-1-1	1	0	0
	C2-10-1	1	0	0
	C2-11-2	2	0	0
	C2-3-1	2	0	0
	C2-3-10	1	28	0
	C2-3-11	1	0	0
	C2-3-2	1	0	0
	C2-3-2-1	2	100	0
	C2-3-3	1	0	0
	C2-3-3-1	1	30	0
	C2-3-5	2	0	0
	C2-3-6	1	0	0
	C2-3-8	2	8	0
	C2-5-1	1	0	0

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WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER : ☐					

C3-10-2	1	0	0
C3-11-1	1	0	0
C3-12-1	2	36	0
C3-12-2	1	0	0
C3-12-3	1	0	0
C3-12-4	1	0	0
C3-12-5	1	0	0
C3-12-6	2	0	0
C3-13-1	2	0	0
C3-13-4	1	0	0
C3-13-5	1	0	0
C3-2-1	1	0	0
C3-3-4	2	0	0
C3-3-4-1	4	66	0
C3-3-7	1	50	0
C3-3-9	1	0	0
C3-4-1	2	0	0
C3-4-4A	1	0	0
C3-7-1	1	0	0
C3-7-2	2	0	0
C3-8-2	1	0	0
C3-8-4	1	0	0
C3-8-5	1	0	0
C3-9-1	1	0	0
C3-9-2	1	0	0
EL-PLUG-M	1	53	0
M27500-16TG2T14	1	0	0
MS21044N4	4	12	0
MS21083-N3	2	0	0
MS21083N6	1	26	0
MS35266-63	2	45	0

Part Specifications

Specifications could not be found.

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
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Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					



Remote Cargo Hook Test Form

C3

MAKE SURE YOU ARE USING THE CORRECT TEST FORM FOR THE CORRECT SOLENOID!

NEW SOLENOID (152951-001)

Work Order 175261

Customer _____

Serial Number 5074639

Date June 11 2018

# of Releases	Load (Lbs.)	Release Method	Remarks	Result	Pass/Fail
1	7,500	Static Hold	Hold for two minutes and reduce load to zero	N/A	Pass.
10	1,500	Electircal, 25 volts	No "hang ups" permitted	N/A	Pass.
2	3,000	Electircal, 22 volts	Current shall not exceed 12.8 A 9.5	A	Pass.
2	2,500	Electircal, 22 volts	Current shall not exceed 12.8 A 9.4	A	Pass.
2	2,000	Electircal, 22 volts	Current shall not exceed 12.8 A 9.4	A	Pass.
2	1,500	Electircal, 22 volts	Current shall not exceed 12.8 A 9.4	A	Pass.
2	500	Electircal, 22 volts	Current shall not exceed 12.8 A 9.4	A	Pass.
1	3,000	Electircal, 20 volts	Current shall not exceed 11.6 A 8.5	A	Pass.
1	3,000	Electircal, 28 volts	Current shall not exceed 16.2 A 11.8	A	Pass.
1	3,000	Manual		N/A	Pass.
1	3,000	Impact Test	Impact shackle 10x , shall not release	N/A	Pass.
1	N/A	Solenoid Ohms	Shall not exceed 1.7-2.0 Ω 2.0	Ω	Pass.
1	N/A	Electircal Continuity	Across both wires	N/A	Pass.

Test Conducted By: Luc Cariviere
Technician

Submit

Signature: _____

QC 5 Small FAB / QA